

*If you are using a printed copy of this procedure, and not the on-screen version, then you **MUST** make sure the dates at the bottom of the printed copy and the on-screen version match. The on-screen version of the Collider-Accelerator Department Procedure is the Official Version. Hard copies of all signed, official, C-A Operating Procedures are kept on file in the C-A ESHQ Training Office, Bldg. 911A*

## C-A OPERATIONS PROCEDURES MANUAL

### 14.20 SMD EMS Process Assessment for Electronic Assembly Operations (AM-522-EAO)

Text Pages 2 through 5

#### Hand Processed Changes

<u>HPC No.</u>	<u>Date</u>	<u>Page Nos.</u>	<u>Initials</u>
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Approved: \_\_\_\_\_  
*Signature on File*  
 Collider-Accelerator Department Chairman      Date

Approved: \_\_\_\_\_  
*Signature on File*  
 Superconducting Magnet Division Head      Date

M. Van Essendelft

# BROOKHAVEN NATIONAL LABORATORY

## PROCESS ASSESSMENT FORM

### I. General Information

Process ID:	AM-522-EAO	PEP ID# 522		
Process Name:	Electronic Assembly Operations			
Process Flow Diagrams:	AM-522-EAO-01			
Process Description:	The process includes the Electronic Assembly Operations conducted in Buildings 902, 905 and 924 associated with the fabrication and operation of superconducting magnets and support systems at BNL. Electronic assembly refers to the installation and interconnection of wires, mechanical connectors and electronic components onto printed circuit boards and within a piece of equipment utilizing solder or conductive epoxy. Section II and the above-referenced Process Flow Diagram provide more detail on the Electronic Assembly Operations.			
Dept./Div.:	Superconducting Magnet			
Dept. Code:	AM			
Building(s):	902, 905 & 924			
Room(s):	N/A			
Point of Contact:	J. Durnan	8236		
Prepared by:	M. VanEssendelft	Reviewed by:	J. Durnan	

### II. Detailed Process Descriptions and Waste Determination

Superconducting magnets are designed to bend and focus ion beams used in accelerator/collider projects at BNL and other laboratories. Superconducting Magnet Division designs, fabricates, tests and repairs superconducting magnets. The magnets are cooled to 4.6°K (and lower) using either liquid helium or supercritical helium gas. At cryogenic temperature, the magnets acquire superconducting properties, thereby greatly reducing the amount of electricity that must be supplied to generate the magnetic field.

Process Flow Diagram AM-522-EAO-01, provided in Attachment 1, graphically depicts the process inputs and outputs for the Electronic Assembly Operations. These diagrams were developed to support fabrication and assembly operations associated with the Relativistic Heavy Ion Collider (RHIC). With the RHIC program operational since 2000, the SMD supports the program in supplying upgrades and repairs as well as doing research and development for institutions around the globe. The processes and controls are still in use and continue to be applicable.







RHIC magnets and magnets for other off-site laboratories are fabricated in Buildings 902 and 924 (currently building 924 has been put into a storage mode until the coil presses are, again, required in support of magnet fabrication). Also located in Building 902 are shops where printed circuit boards utilized in the RHIC magnets and other components are assembled by wiring and interconnecting the various electronic components to the printed circuit boards. In addition to electronics assembly operations, Building 902 contains a small staff shop, cryogenic helium production, magnet testing systems, small-scale plating/bus-bar plating operations and the final magnet mechanical assembly operations. Magnet subassembly fabrication is also performed in Building 905 when the area in 902 does not provide sufficient space.

Complete lists of chemicals utilized by the Superconducting Magnet Division are tracked using the BNL [Chemical Management System](#) (CMS). Current lists of chemicals assigned to the Division can be found using the BNL CMS web site. Not all of the chemicals listed in the CMS list or located in SMD Buildings are used on a regular basis. When projects are completed, the chemicals used for that particular project typically remain in storage cabinets at the building for possible use in the future.

In general, solder waste, scrap wire and other process materials generated in SMD Buildings during electronic assembly operations are reused when possible, and recycled as specified in the table below. Soldering/flux fumes are typically vented through a smoke eater to ambient air.

### **III. Regulatory Determination of Process Outputs**

Electronic assembly operations conducted in SMD Buildings are similar. Wire and/or solder are used for the interconnection of printed circuit boards and electronic parts, and the assembly of the electronic parts within the magnet. Scrap wire is reused depending on the length or discarded in the regular trash. Wire is supplied on plastic spools that are reused when empty or discarded in the regular trash. Electronic components are connected to printed circuit boards using lead/tin, silver/tin or indium solder. Solder tailings are collected and either reused (by melting in solder pots) or sent to Plant Engineering for recycling. Portable fan systems (with filters) are typically used to disperse the small amount of fumes from the soldering operations. If practical, soldering is performed in one of the two (2) Building 902 fume hood systems. The exhaust from these hoods operations has been categorized as trivial sources under the laboratory's NYSDEC Title V permit. Logbooks are maintained at the hoods to record the estimated emissions from this and other processes. Postings at these points list evaluated activities. Chemicals such as ethanol and acetone are stored in large (typically 5 gallon) containers within storage cabinets and are used to refill reusable plastic squirt bottles. Empty containers from other chemicals used in smaller quantities are discarded in the regular trash. Paper rags are used for cleaning and the spent rags are discarded in the regular trash.

Waste ID	Waste Description	Determination/Basis	Waste Handling	Corrective Action Required
 1.1	Wire scraps	Non-hazardous solid waste as determined by process knowledge	Waste is reused or discarded in the regular trash (due to limited amount of unused material, recycling is not warranted)	None
 1.2	Wire spools	Non-hazardous solid waste as determined by process knowledge	Waste is reused or discarded in the regular trash	None
 1.3	Soldering fumes	Non-hazardous vapors as determined by process knowledge	Vapors are dispersed to ambient air using small fans or NYSDEC permitted hoods	None
 1.4	Spent rags and empty containers	Non-hazardous solid waste as determined by process knowledge	Waste is discarded in the regular trash	None
 1.5	Waste Solder	Hazardous waste if it contains lead or silver and not stored in recycling containers	Reuse if possible, or recycle through Plant Engineering	None
 1.6	Evaporative VOC emission to room	Non-hazardous fugitive emission	Released to room	None

#### IV. Waste Minimization, Opportunity for Pollution Prevention

Electronic assembly operations associated with SMD programs undergo a safety review by the ESH Coordinator prior to implementation. Evaluation for waste minimization and environmental compliance are included in this review as well as during the Engineering Design Review Process (for new programs) and/or the [Work Planning and Control Process](#) (ESH C-A-OPM 14.20 (Y))

Standard 1.3.6). The evaluation of waste minimization opportunities is most effective during the planning stages of an experiment or operation. In addition, all anticipated waste streams from an experiment or operation are be evaluated for environmental compliance prior to implementation to ensure that the appropriate waste management procedures and facilities are in place.

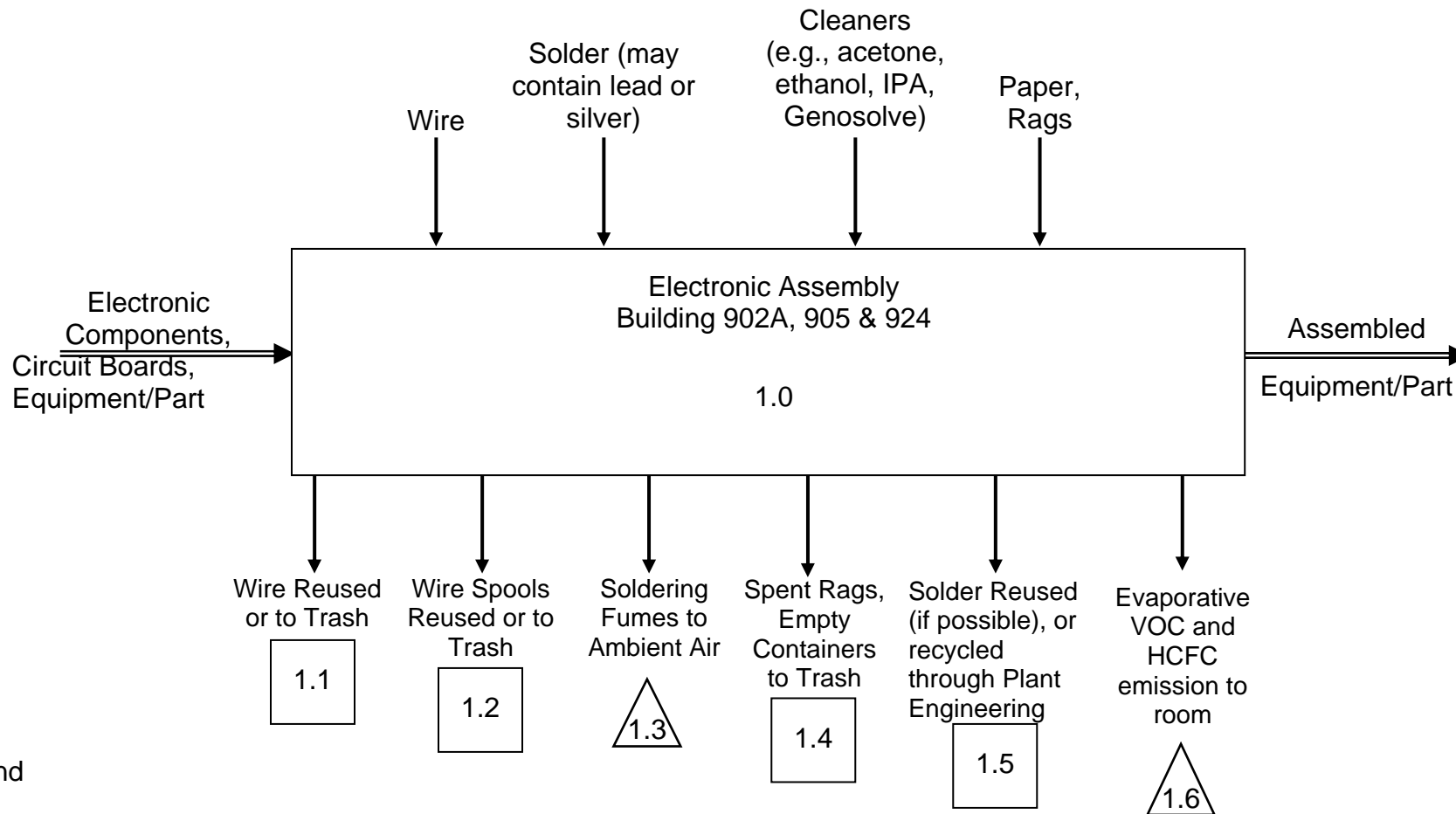
During the initial effort of evaluating SMD's processes for Pollution Prevention and Waste Minimization Opportunities, each waste, effluent, and emission was examined to determine if there were opportunities to reduce either the volume or toxicity of the waste stream. Consideration was given to substitute raw materials with less toxic or less hazardous materials, process changes, reuse or recycling of materials and/or wastes, and other initiatives. These actions were documented in this section of the original process evaluation. Action taken on each of the Pollution Prevention and Waste Minimization items identified can be found in the Environmental Services Division's PEP Database. Further identification of Pollution Prevention and Waste Minimization Opportunities will be made during annual assessments of the SMD processes. If any Pollution Prevention and Waste Minimization Opportunities are identified, they will be forwarded to the Environmental Services Division for tracking through the PEP Database.

#### **IV. Assessment Prevention and Control**





During the initial effort of evaluating SMD's Assessment, Prevention, and Control (APC) Measures, operations, experiments and waste that have the potential for equipment malfunction, deterioration or operator error, and discharges or emissions that may cause or lead to releases of hazardous waste or pollutants to the environment or that potentially pose a threat to human health or the environment were described. A thorough assessment of these operations was made to determine: if engineering controls were needed to control hazards; where documented standard operating procedures needed to be developed; where routine, objective, self-inspections by department supervision and trained staff needed to be conducted and documented; and where any other vulnerability needed to be further evaluated. These actions are documented in this section of the original process evaluation. Action taken on each of the Assessment, Prevention and Control Measures is documented in the Environmental Services Division's PEP Database. Further identification of Assessment, Prevention and Control Measures will be made during annual assessments of SMD processes. If any Assessment, Prevention and Control Measures are identified, they will be forwarded to the Environmental Services Division for tracking through the PEP Database.

ATTACHMENT 1

PROCESS FLOW DIAGRAMS



#### Legend

-  - Solid Waste
-  - Air
-  - Wastewater
-  - Sanitary System

Filename: SMD Flowchart 522 Rec D

BROOKHAVEN NATIONAL LABORATORY  
PROCESS ASSESSMENT PROGRAM  
**Superconducting Magnet Division – Electronic Assembly Operations**  
**Process Flow Diagram – SMD Buildings**